Work Orde January-30-14 1		2604		*112	2604*							Page 1
Item ID: Revision ID:	D3428-1		A	Accept	*N900	040	100	* s	etup		*N	S1*
Item Name:	Placard		12							Stop	*N	S2*
Start Date: Required Date: Reference:	1/30/14 1/30/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:						
Approvals:	Process Pla	n: <u>MLS</u>	Date: 14-02-03	Tooling: SPC (Y/N):		ate:	-	F	Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
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D3428	Rev	A										
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*110 *110*		Receive & Inspect for D	amage & Mat'l Certs	0.00						/.		(1)
Packaging		Memo		0.00				1 7	1/2	//1	-(

Ensure material release note is attached

Packaging

Work Order: Date Disposition	DQA:			Date:										TRACT
Work Order: Part No.							WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE
Part No.	QA Closed:			Date:							V	Vork Order up	date only	
Part No	Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
Part No.		-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
NCR No.	Part N	lo.			•					├ ──		Pro	d. Eng. Coor.	- T
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Description Date Verification QC Inspector Design Doc/Data Description Description Date Date Date Verification QC Inspector Design Doc/Data Description Date Date Date Date Date Date Date Date		-					Use-as-is		Therr	noforming	Finishing	Rec/Sto	e/Packaging	Other
Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector	NCR N	lo.				_	Suspected Unapproved			Large Fab	Composite		Supplier	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Pandling Gear FAULT CATEGORY Landing Gear General Bending General Bending Centre Not Concentric Broken/Damage/Defect Hardware Part Incorrect Set-up Cracks Crimp/Kink/Ripple/Wave Burss Inspection Incomplete/Unqualified Part Lost/Missing Weld Countersink Misaligned/off center Positioned Wrong	Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &		
Doc/Data	Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Marks/Chatter Drill Holes Off-set			,	-	Tube	-	1 -	\vdash	4					
Turning Sequence Finish Out of Calibration			•			\vdash	•	-	-1					
			_				Fit/Function		4			_		

Work Order ID 112604 *112604* Page 2 January-30-14 11:51:15 AM **Item ID:** D3428-1 Accept Setup Start *N900040100* **Revision ID:** Stop Placard **Item Name:** *10* **Start Qty: 10.00 Start Date:** 1/30/14 **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Start Run **Tooling: Approvals:** Process Plan: Date: Date: Stop QC:_____ Date:_____ SPC (Y/N): Date: Reject Sequence ID/ Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Operation **Work Center ID** Code Qty Qty Number Stamp **Description** Run Hours QC6- Inspect dimensions to drawing 0.00 120 27 *120* OC Memo **Quality Control** Identify as per dwg & Stock Location: 57-042 130 *130* Packaging 0.00 Memo **Packaging** QC21- Final Inspection - Work Order Release 0.00 140 #14-02-13 DI4-02-13 *140* 0.00 QC Memo Quality Control

DQA:			Date:											•	TRAC
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Nor	k Order up	date only	\neg	AEROSPACE
QA Closed.			Dute.	<u> </u>								· · · · · · · · · · · · · · · · · · ·			
Work Orde	er:					DISPOSITION				AGAINST [)EP/	AKIMENI	PROCESS _		
	•				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	_		d. Eng. Coor.	_	Quality
NCR N	۱o. ِ					Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier		Other
Post					Dosc	ription of work order update	\sqcup	nitial	Acti	ion .	\neg	Sign &		\neg	**************************************
Root Cause		Date	Step	Qty	Desci	or non-conformance	ı	iilliai iief Eng	1		ļ	Date	Verification	.	QC Inspector
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Unapproved															· · · · · · · · · · · · · · · · · · ·
							FA	ULT CA	TEGORY						g
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		Bending				Bend	匚	Folio/	Program		\dashv	Outside Dim	ensions	-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L_	Grain			Щ ^с	Over/Under	tolerance		Set-up
	$\overline{}$	Cracks				Broken/Damage/Defect		Hardwa				Part Incorre			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u></u>	Inspect	ion Incomplete/Un	nqualified		Part Lost/Mi	ssing	-	Weld
	\vdash	Cuffs				Contamination		-1	tions Incomplete/L	Jnclear	_	Part Moved	Ĺ		Wrong Stock Pulled
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		Inspectio	•	Tube		Drawing	\vdash	Misrea			_			_	
		Marks/Ch				Drill Holes	_	Off-set			_				
		Turning S	-			Finish		4	Calibration		_				
<u> </u>	1	Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence						

Picklist Print

January-30-14 11:51:15 AM

Work Order ID:

112604

Parent Item:

D3428-1

Parent Item Name:

Placard

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP:

A05.08.10New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3428-1P		Purchased	No			110	Each	0.0000	1	10	1	/./	(in)
Placard									-		10141	4/2	

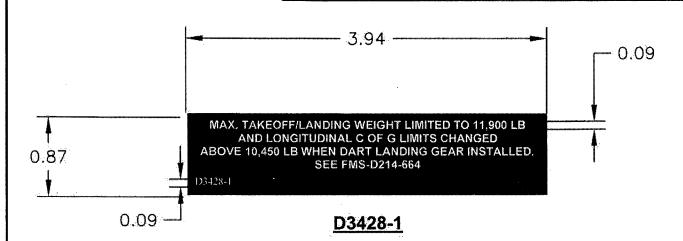
Page 1

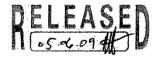
DQA:			Date:												TRACE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				_		AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	or.					DISPOSITION				AGAINST I	DEI	PARTMENT	PROCESS		
Work orac	•				_	Rework			Skid-tube	Crosstube	- 1		Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•	•		·• · · · · · · · · · · · · · · · · · ·		Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	۱o. ِ					Suspected Unapproved			Large Fab	Composite [Supplier		
Root					Desci	ription of work order update	ı	nitial	Actio	on		Sign &			· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification	1	QC Inspector
Design															
Doc/Data															
Equip/Tooling													• •		
Handling/Pre													!		
Material									,						
Operator			į												
Offset/Setup															
Process															
Supplier Training				1											
Transport		-													
Unapproved									ļ						
							FA	ULT CA	TEGORY			<u> </u>			
Landi	ng (Gear				General									
		Bending				Bend		Folio/F	Program			Outside Dim	ensions		Pressure/Forced
- -		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	લ		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unc	qualified		Part Lost/Mi	ssing		Weld
	L	Cuffs				Contamination	L	4	tions Incomplete/Ur	nclear	_	Part Moved	L		Wrong Stock Pulled
	_	Crushing			\perp	Countersink	<u> </u>	4	gned/off center		_	Positioned V			l
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislab		l		Power Loss/	Surge [Other
	<u> </u>	Inspectio	•	Tube	<u> </u>	Drawing	<u> </u>	Misrea							
	_	Marks/Ch			-	Drill Holes	-	Off-set							
		Turning S			<u> </u>	Finish	\vdash	-	Calibration			-			
	1	Wave/Tw	rist in Tub	oe -		Fit/Function	1	Out of	Sequence						



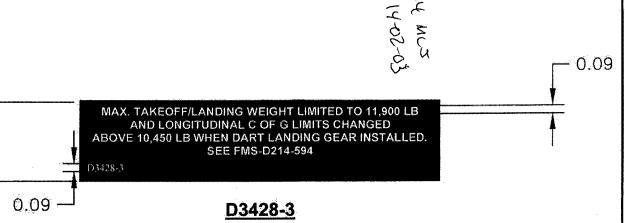


DESIGN P		DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECK	#-	APPROVED	DRAWING NO.	REV. A SHEET 1: OF 1
DATE			TITLE	SCALE
05.0	6.07		PLACARD	1;1
A		05:06:07	NEW ISSUE	





0.87



- 1) MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22919

Purchase Order Date 2/7/2014 PO Print Date 2/7/2014

Page Number 1 of 3

Order From:

STUDIO DE LETTRAGE 2001 210 MAIN WEST HAWKESBURY, ON K6A 2H6 CA

VC-STU001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

613 632 5449

Yours ppd

Buyer

Chantal Lavoie

Customer Tax #

Customer POID

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

	hip Acct:	·p·		rob		Destination-Collect	
Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable		Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments Delivery Comments		Promise Date		Measure		
1 I	D3312-1P	Placard	2/13/2014		12.00	\$6.67	\$80.00
			Yes 2/13/2014		Each		
	AS PER DWG D3312 REV. A 3112499						
						Line Total:	\$80.00
2 r	O3428-1P	Placard	2/13/2014		12.00	\$6.67	\$80.00
			Yes		Each		
	AS PER DWG D3428 REV. A 3112604		2/13/2014				
						Line Total:	\$80.00

D4597-1P

Placard

2/13/2014

2/13/2014

Yes

12.00 Each

\$6.67

\$80.00

AS PER DWG D4597 REV. A

B112705

PO Instructions: Procurement Quality Clauses

A005 right of entry

A013 self life contolled material 80% A026 certification of material conformance A040 notification of quality escape A042 dart notification by supplier

Note:

Studio de Lettrage 210 Main Street W Hawkesbury, Ontario K6A 2H6

Dart Aerospace Ltd

1270 Aberdeen Hawkesbury, Ontario K6A 1K7

INVOICE

Invoice No.:

21617

Date:

02/10/2014

Ship Date:

02/11/2014

WO11804

Page: Re: Order No. 1

Sold to:

Ship to:

Dart Aerospace Ltd

Hawkesbury, Ontario

Business No.:	82500 7651 RT	0001				
Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12 12 12 12 12	D3312/1P D3428/1P D4597/1P D4917/315P D4917/300P D4917/320P D4917/332P PO#22919 Chantal Lavoie H - HST 13% HST	H H H H H H H	6.6667 6.6667 6.6667 6.6667 6.6667	80.00 80.00 80.00 80.00 80.00 80.00 80.00
						72.00
Studio de Lettrage I			andrea (P. 19. 1. 19. Augustus (P. 1992).			
Shipped By: Comment: Sold By:	Tracking N	lumber:			Total Amount	632.80

Customer - \	ate of Conformity*	
Studio LEX	teagé	•
Purchase Order #: Packing Slip #:	Part #:	Serial #:
22919 1804 Description: D3312/1P, D3428/1P,	Quantity:	
04597/19, 04917/3159, 04917/3009 04917/320P, 04917/332P		
<u>04917/320P, 04917/33≥P</u> Certification:		
· -		
We hereby certify that:		
. The above the listed items were man		
accordance with applicable drawings	and/or specifications	s;
All work was assemblished in assemb	once with the Dest A	
 All-work was accomplished in accordance Purchase Order. 	ance with the Dart A	erospace
ruichese Cruei,		
	•	
3. Results of all inspections, chemical or	r physical tests, as w	vell as other evidence.
Results of all inspections, chemical or which shows the acceptability of raw n		
	materials, parts and/o	or assembly
which shows the acceptability of raw r	materials, parts and/o	or assembly
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Authority: AUERY APPROVAL: Natasha belanger-	materials, parts and/office inspection at any	or assembly

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PRODUCT DATA SHEET



Avery[®] IPM™ 2031

issued: 01/04/2005

Introduction

Avery[®] IPM[™] 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery[®] IPM[™] 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery[®] IPM[™] 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm:

80-micron premium white calendered, topcoated vinyl.

Adhesive:

removable, acrylic based

Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant wit specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery[®] IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminates and Avery® Digital Print Media"

Always test your combination of Avery[®] IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

Durability:

Avery[®] IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorspan. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery[®] IPM™ Outdoor warranty.





Physical properties

Features

Caliper, facefilm

Gloss

Dimensional stability

Adhesion, initial Adhesion, ultimate

Flammability

Accelerating ageing

Shelf life

Removability

Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC

Durability²

Overlaminated with DOL 4300

FINAT FTM-1, stainless steel

FINAT FTM-1, stainless steel

DIN 53587, 500h exposure

Stored at 22° C/50-55 % RH

Overlaminated with DOL 1000, DOL 1100

with overlaps

Overlaminated without overlaps

Test method1

ISO 2813, 20°

ISO 534

DIN 30646

for static applications only

Without overlaminate and used for static, Non-abrasive application ONLY

Results

80 µm 1%

0.3 mm. max

180 N/m 260 N/m

Self extinguishing

No negative impact on film

Performance 2 years

up to 1 year

5 years

3 years

2 years

18 months

Only when printed with ENCAD GO, HP and Colorspan pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

Features

Application temperature Service temperature

Results

Minimum: +10°C -20°C to +80°C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Avery branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



